

Work Order ID 164947

Thursday, August 10, 2017 9:06:09 AM

164947

Page 1

Item ID: D3916-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib Assembly

Start Date: 8/25/2017 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 8/30/2017 Req'd Qty: 8.00 ***8*** Customer:

Reference: **AUG 10 2017**
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3916	A								

100 0.00
100
Large Fab
Large Fab
Memo
1- Cut tube 50"
2- Bend tube with manuel pipe bender as per DT9567
*** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
3- Trim access tube material to finish size as per dwg D3916
4- Drill and chamfer holes as per dwg D3916-1 using DT9605

81 0.171 2017-8-30

105 0.00
105
QC
Quality Control
Memo
QC6- All purchased or subcontracted products

8 **SEP 06 2017** **DAS 24 9-89**

~~Approved~~
~~615~~

12

Thursday, August 10, 2017 9:06:09 AM

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

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Item ID: D3916-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Rib Assembly
Start Date: 8/25/2017 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 8/30/2017 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA004</u>	0.00							
130									
Packaging	Memo	0.08							
Packaging	LOCATION: WA004								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.80							
Quality Control									

8x ~~SC~~ 2017-09-11

17/9/13 

 SEP 11 2017

Picklist Print

Thursday, August 10, 2017 9:06:08 AM

Page 1

Work Order ID: 164947

164947

Parent Item: D3916-041

D3916-041

Parent Item Name: Rib Assembly

Start Date: 8/25/2017

Required Date: 8/30/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1

Manufactured

No

100

Each

92.0000

7

56

D3759-1

Bushing

**

B164367256 CG
17-09-06

Location

Loc Qty

Loc Code

WA004

92

163317

12

163886

80

M304TS0.750W.049

Purchased

No

100

f

627.1895

4.166

35.08211

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

**

D.M.L 2017-8-31

Location

Loc Qty

Loc Code

WA004

627.189474

M137401

0.689474

M137625

285

M137824

2

M137934

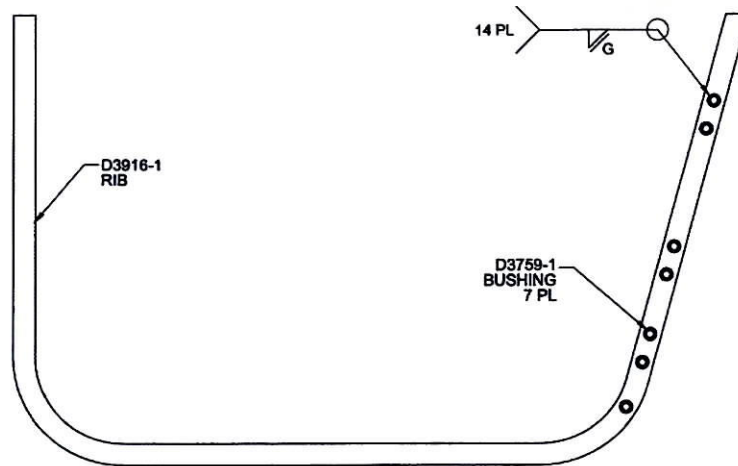
39.5

M138160

300

137625

36



D3916-041 RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDING
WITHOUT NOTICE
WORK ORDER
NO. 164947
AUG 10 2017

RELEASED
2010-03-12
MTP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Purchase Order Receipt Listing

Wednesday, May 24, 2017 3:29:05 PM

Page 1 of 1

All amounts are calculated in domestic currency.

All Vendors PO ID PO36329 Receipt Dates from 5/23/2017 to 5/23/2017 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID/Vendor Name		VC-MET002 Metaux Solutions									
PO36329	1		M304TS0.750W.049 f		5/24/2017	5/23/2017	500.0000	\$2.78	0.0000	0	\$1,390.80
CAD	No		304 SQ Tube 45 f		500.0000	PLOU01		\$1,390.80	0.0000	0	
			.75x.75x.049W								
			m137625								
	3		MSTEEL-A2- f		5/24/2017	5/23/2017	24.0000	\$9.06	0.0000	0	\$217.40
	No		B0.500X1.250 1.275 f		24.0000	PLOU01		\$217.40	0.0000	0	
			AISI A2 TOOL								
			STEEL BAR, 0.500								
			X 1.250								
			m137625								
	4		71401-45		5/24/2017	5/23/2017	1.0000	\$0.00	0.0000	0	\$0.00
	No		PROCUREMENT		1.0000	PLOU01		\$0.00	0.0000	0	
			QUALITY								
			CLAUSES								
			m137625								

Total Received Quantity: 525.0000
Total Qty to Inspect (PO U/M): 0.0000
Total Reject Quantity: 0.0000
Total Receipt Value: \$1,608.20
Total Balance Due Quantity: 0.0000



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36329**

Purchase Order Date 5/16/2017 1:03:43 PM
PO Print Date 5/16/2017

Page Number 1 of 2

Order From :

VC-MET002

Ship To : DART AEROSPACE LTD

METAUX SOLUTIONS
2625 BOUL JACQUES-CARTIER EST
LONGUEUIL, QC J4N 1L7
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
MAY 16 2017

Contact Name

Vendor Phone 800 558 8858

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

Journey Freight collect

FOB

Destination-Collect

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	M304TS0.750W.049	304 SQ Tube .75x.75x.049W	5/23/2017 Yes 5/23/2017		500.00 f	\$3.80	\$1,900.00
MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBING AS PER ASTM A554 MILL FINISH OR AS PER ASTM A269 MILL FINISH							
Line Total:							\$1,900.00
3	MSTEEL-A2-B0.500X1.250	AISI A2 TOOL STEEL BAR, 0.500 X 1.250	5/23/2017 Yes 5/23/2017		24.00 f	\$12.38	\$297.00
MATERIAL: AISI A2 TOOL STEEL, ANNELED CONDITION AS PER A681							
NOTE: TOLERANCE -0+0" AS PER QUOTATION #16619 CUT AT 1.25"							
Line Total:							\$297.00

SP17-5-24

Note:

5/16/2017

Shipping Order

19/05/2017

METAUX SOLUTIONS INC
2625 BOUL JACQUES CARTIER EST
LONGUEUIL, QUEBEC
J4N 1L7
Tel.: 450 641-3330

Order : 125634
Reference : 36329
Ship : PICK UP / PICK UP

Customer: 6323336

Ship To

DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7

Same

Tel.: 1 613 632-3336

Item No.	Description	Qty	Qty. Delivered	B/O Qty
	***** FACTURER E-MAIL ***** SUPER IMPORTANT SUR LE PACKING SLIP INSCRIRE LES HEAT N			
SSQT34340494	304 SQ TUBE .750 X .049 WALL 25 X 20' **** <u>HT, TBG113301</u>	500	<u>500</u>	<u>e</u>
TP12A2	A-2 PLATE TFA 1/2" THICK ht# 59498 2 X 1.25" -0+0 X 144" R/L	56	<u>56</u>	<u>e</u>

SHIP JOURNEY COLLECT
HP

817-5-24.

Shipping : _____
Package No : _____
Merchandise Received: _____
Ref. : _____

檢驗證明書
INSPECTION CERTIFICATE

524彰化縣溪州鄉中山路四段270號
No.270,Sec.4,Jungshan Rd.,Shijou Shiang,
Chang-Hwa,Taiwan,R.O.C.
http://www.ycinox.com
TEL : +886-4-8899666 FAX : +886-4-8899770



客戶名稱 Customer		客戶編號 Customer No.		FCA027		證明書編號 Certificate No.		170110P0122	
產品名稱 Production		STAINLESS STEEL WELDED TUBE		商業發票號碼 Commercial Invoice No.		J16120312		證明書日期 Date of Issue	
規格名稱 Specification		ASTM A554-16		客戶採購案號 PO No.		P006792		訂單編號 Order No.	
鋼種 Steel Grade		MT-304		提貨單編號 Weight No.		C17010081		P.I.號碼 P.I.NO.	
PI 1611-087									

項目 Item No.	爐號 Heat No.	產品規格 Product Description			化學成份(%) Chemical Composition										拉伸試驗 Tension Test			*01 硬度試驗 HRB
		尺寸 Dimension	數量 Quantity Pcs	表面 Finish	C	Si	Mn	P	S	Ni	Cr	伸長率 E.L.	抗拉 T.S.	降伏 0.2%Y.S.				
															MPa	%		
Specification																		
1	TBG113301	3/4" (19mm) x 3/4" (19mm) x 0.049" (1.25mm) x 20FT	60	MILL	80	100	200	45	30	1100	2000							
2	TBG091285	2 1/2" (63.5mm) x 2 1/2" (63.5mm) x 1/4" x 20FT	5	MILL	44	47	89	35	4	806	1820	312	660	52	85			
3	TBG092176	2" (50.8mm) x 2" (50.8mm) x 1/4" x 20FT	13	MILL	19	28	141	26	3	800	1828	297	620	53	84			
4	TBG121892	3" (76.2mm) x 3" (76.2mm) x 0.12" (3.05mm) x 20FT	23	MILL	24	31	139	28	8	804	1821	305	649	52	84			
5	TBG122730	3" (76.2mm) x 3" (76.2mm) x 1/4" x 20FT	13	MILL	24	44	154	29	1	800	1811	308	690	50	88			
6	TBG113722	4" (101.6mm) x 4" (101.6mm) x 0.12" (3.05mm) x 20FT	23	MILL	18	31	137	33	7	802	1827	298	626	53	86			
7	TBG113712	4" (101.6mm) x 4" (101.6mm) x 0.180" (4.57mm) x 20FT	13	MILL	16	37	104	24	3	804	1837	289	651	52	83			
8	TBG113689	4" (101.6mm) x 4" (101.6mm) x 1/4" x 20FT	25	MILL	19	31	138	35	7	804	1827	303	628	53	87			
9	TBG122118	1 1/4" (31.8mm) x 1 1/4" (31.8mm) x 0.12" (3.05mm) x 20FT	50	MILL	21	44	156	26	2	810	1813	301	659	53	87			
10	TBG113247	2" (50.8mm) x 2" (50.8mm) x 0.12" (3.05mm) x 20FT	25	MILL	42	48	89	34	2	813	1811	274	644	55	84			
11	TBG113248	2" (50.8mm) x 2" (50.8mm) x 0.12" (3.05mm) x 20FT	25	MILL	54	48	134	35	2	812	1819	275	612	53	82			
			44	41	89	39	6	801	1808			280	644	53	84			
TOTAL:			275															
附註 Remark				This certificate complies to 3.1/EN 10204:2004.														
				Visual Inspection (Surface) and Dimension Check : OK														
Surveyor By				Manager of Quality Assurance Department														
N/A				茲證明本文所列產品，均依材料標準製造及試驗，並符合標準之要求，與無輻射污染 We hereby certify that material described herein has been manufactured and tested with satisfactory results in accordance with the requirement of the above material specification. The material described above has been found free of radiation by raw material supplier. 1.ISO 9001:2008 (No.01 100 056299) 2.PED / AD2000 (No.01 202 TW00Q-05 0105) 3.ISO 14001:2004 (No.01 104 822 096385) 4.OHSAS 18001:2007 (No.01 113 822 096385)														

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M304750.750W.049

PO / BATCH NO: 1036329/M137625

DATE: MAY 25 2017

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 500'
 QUANTITY INSPECTED: 500'
 QUANTITY REJECTED: 0

THICKNESS ORDERED: .049
 THICKNESS RECEIVED: .045
 SHEET SIZE ORDERED: NA
 SHEET SIZE RECEIVED: NA

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	(Y) N	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	(Y) N	
CORRECT MATERIAL PER M-DRAWING	(Y) N	ASTM A554
CORRECT THICKNESS	(Y) N	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	(Y) N	HT # T8G113301
CORRECT MATERIAL IDENTIFICATION	(Y) N	
CORRECT M# ON THE MATERIAL	(Y) N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW				
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D
SIZE OF TEST SAMPLE				
HARDNESS / DUROMETER READING				

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>CB</u>		SIGNED OFF BY: _____
DATE: <u>MAY 25 2017</u>		DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in